

Work Order ID 70614

Monday, June 13, 2011 12:33:57 PM



Page 1

Item ID: D3264-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 6/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10/13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan

Accept
CodeReject
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3264	Rev A2

100



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 5.700" LONG

0.00

B.A 11/07/21

6 ✓

110



HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOILIO FA447
FOLIO REV: 44
DWG REV: 42

0.00

11/08/22

6 ✓

DEBURR AS PER DWG

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC2- Inspect parts off machine FAI/FAIB

0.00

a/f 11/08/22

6 0

QC

Memo

0.00

Quality Control

130



QC8- Inspect parts - second check

0.00

b.a 11/08/23

6 6

QC

Memo

0.00

Quality Control

140



Chemical Conversion Coat per QSI005 4.1

0.00

6X 8m 11/08/24

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Powdercoat

Powder Coating

M 117745 ^{Memo}

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Start Time: 3:45
Temp: 320°F
Finish Time: 4:15

6x Ø M 11/08/24

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

6 BL 11-8-24

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: ST144

0.00

SL

SL SP 11-0825

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 70614

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Monday, June 13, 2011 12:33:57 PM

Item ID: D3264-1

Accept



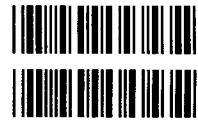
Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 6/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

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NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, June 13, 2011 12:34:03 PM

Work Order ID: 70614



Parent Item: D3264-1



Parent Item Name: Bracket

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A□04.09.02□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50 0		Purchased		No			f	11.5167		3			

6061-T6 Bar 1.25 X 4.50



Location	Loc Qty	Loc Code
MAT004	11.5167	
✓ 112628	11.5167	

3.000 ft 11/07/21

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	20014
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264	Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	.688	—		Vern	ML-7
0.063	+/-0.010	.063	—		"	"
0.125	+/-0.010	.125	—		"	"
0.875	+0.010/-0.020	.882	—		"	"
0.062	+/-0.010	.063	—		"	"
R0.03	+/-0.030	R.030	—		R-L	
R0.13	+/-0.030	R.125	—		"	
1.00	+/-0.030	1.008	—		Vern	ML-7
0.125	+/-0.010	.125	—		"	"
0.600	+/-0.010	.600	—		"	
4.000	+/-0.005	4.000	—		"	
0.750	+/-0.010	.749	—		"	
Ø0.194	+0.005/-0.000	Ø.195	—		"	
5.50	+/-0.030	5.499	—		"	
0.125	+/-0.010	.125	—		"	
0.063	+/-0.010	.063	—		"	
R0.25	+/-0.030	R.250	—		R-L	
4.27	+/-0.030	4.270	—		Vern	ML-7
R0.30	+/-0.030	R.300	—		R-L	

Measured by:	<i>ark</i>	Audited by:	<i>B.A</i>	Prototype Approval:	N/A
Date:	11/08/22	Date:	11/08/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD <i>JK</i> <i>DA</i>	

W/O:

WORK ORDER CHANGES

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NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED

S U B J E C T

WITH

WORK ORDER

NO. 6

110.

1

AFERD M&P

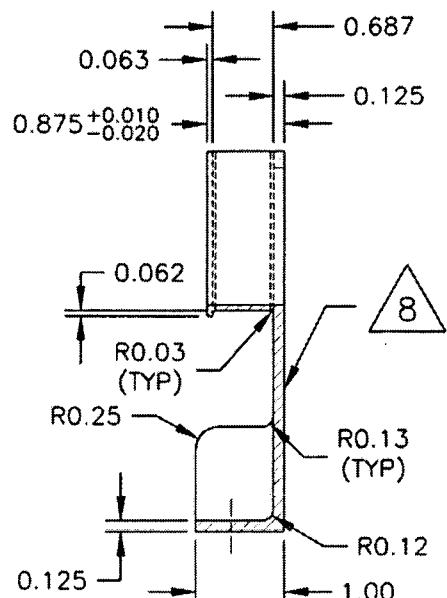
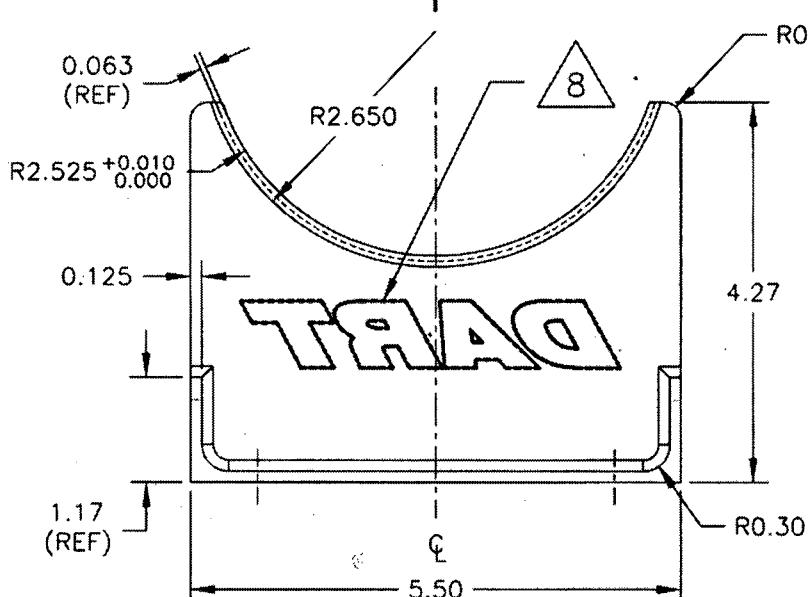
A circular stamp with the words "COPY ISSUED" printed in a clockwise circular pattern.

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. D3264	REV. A SHEET 1 OF 1	
DATE 04.04.20		TITLE BRACKET	SCALE 1:2	
A	04.04.20	NEW ISSUE		

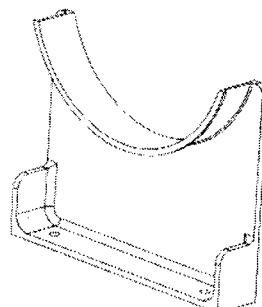
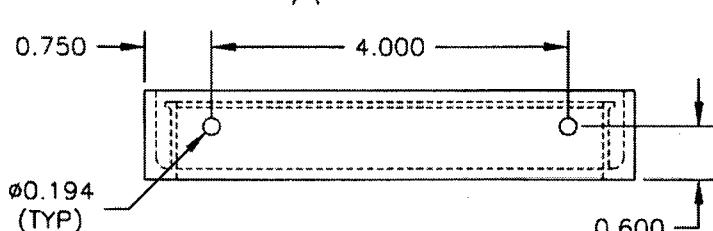
RELEASED
04-09-09 AF

04.09.09 AF

3



SECTION A-A



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH
(MIN) TOOL RADIUS OF 0.25

W/O:

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